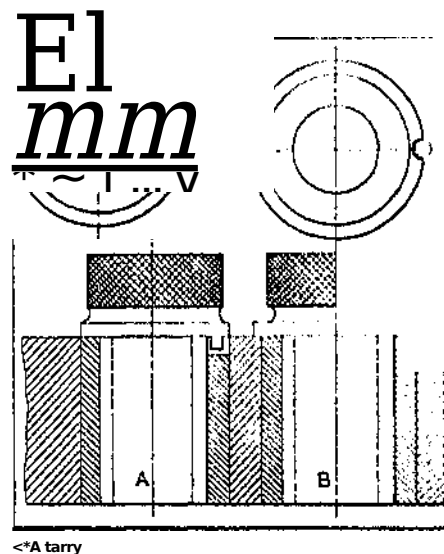


but it does not add the convenient means for removing the bushing as does the clog. To make such a bushing more easily removable, the arrangement shown in Fig. S is probably the most common. A step *A* is turned down on the head, which, in this case, will have to be a little larger in diameter. This step permits some kind of a tool a screw driver, for instance, to be put underneath, and with a jerk the bushing may be lifted enough to get a good hold on it. The half-round slot at *B* is milled or filed in the periphery of the head, and fits over a pin or screw which is fastened in the jig body, as mentioned before.



&lt;A tarry

**Fig. ii. Methods used for**  
Praventlag Jig Bushings from  
Turning

In Fig. u are shown three methods of holding bushings to prevent them from turning, the methods all being on the principle described: *A* shows a bushing having a pin inserted which slips in a slot cut in the lining bushing; *B* shown u hushing having a slot milled through the collar, a pin being located in the jig to engage this slot; and *C* illustrates a more elaborate device that is sometimes used. The stop button which is fastened to the jig prevents the bushing from being drawn out of the liner while withdrawing drills or reamers, as well as preventing it from turning.

The following method for holding slip jig bushings in place